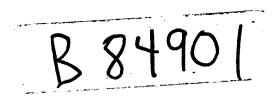
Work Order ID 84908 May-29-12 1:05:02 PM			*84908*								Page
Revision ID:	D209-669-014 Skidtube RH			Accept	*N90	00040	100)*	Setup Sta	1/1	S1* S2*
Start Date: 2 Required Date: 1 Reference:		art Qty: 1.00 eq'd Qty: 1.00	*1* *1*		Cust Ito Custom						
	Process Plan:	MCJ	Date:\2/05	\\ \frac{2}{\sqrt{SPC (Y/N):}}		Date:	- ···		Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center ID		eration scription		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	n Nbr		·· ···· ····· ···· ··· ··· ··· ··· ···	···· —						
D209-669-014 DSI 9450	Rev B Rev A		Λ								
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110	Picl	k Kit		0.00							
*11 0 * Packaging		Memo		0.00						121	4/25/



Packaging

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _					
		solution:	Dispositio	n: <u>'</u>	_ QA: N/C C	osed:		Date: _					
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	Vork Order ID 84908 Say-29-12 1:05:02 PM			*84908*								Page 2
Item ID: Revision ID: Item Name:	D209-669-0 Skidtube RH	14		Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	*N.	S1*
Start Date: Required Date: Reference:	29/05/2012 : 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	D:					I W	. 7/
Approvals:	Process Pla	nn:	Date:	Tooling:	D	 ate:	_		Run	Start	*N	R1*
			Date:	SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC4- 100% Inspect kits Memo	for completeness	0.00 DAS 0.00 16	17/10/18		Code				· · · · · · · · · · · · · · · · · · ·	
*130		Packaging		0.00								
Packaging Packaging		Memo Identify and Location:	pack for shipping as per	0.00 PPPD209-669-014					<u> </u>		(12)	7/18
*140		QC21- Final Inspection -	Work Order Release	0.00						12 1	17/18	3 A
QC		Memo		0.00							-//-	/

Memo

Quality Control

12/7/18 94 MF 1207-18

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Work Order ID: 84908

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Parent Item:

D209-669-014

Parent Item Name: Skidtube RH

84908
D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

New IPP 08.02.13 new issue EC, verified by:DD IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

		2 (<i>-</i> 5.								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D209-669-043		Manufactured	No			110	Each	2.0000		1			11
D209-669 Replacement Skidtube	9-043								**	81	4901		N
				Locatio	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				Mezz			2						
					39205		1				_		
					39206		1		_				
D2917-2		Manufactured	No			110	Each	1.0000	2	2		\wedge	
*D2917-23 Saddle RH	*								** B	849	39	<u>, Uz</u>	
				Locatio	<u>n</u>	Loc	<u>Otv</u>	Loc Code					
				ST424			1						
/					52129		1				_		
D2918-2		Manufactured	No			110	Each	1.0000	2	2	_		,
> *D2918-2 ³ Saddle RH	k								** B	84940	8P	12	17/1254
				Locatio	<u>n</u>	Loc	<u>Qty</u>	Loc Code					
				ST424			1						
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Dail Aci	vapace	LIG										
W/O:			WORK ORDER CHANGES									
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			Chief Eng	Chief Eng	Date							
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MS21042I 4

 Location
 Loc Qty
 Loc Code

 ST300
 4095

 119075
 125

 121011
 713

 121444
 2957

 121652
 300

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W/O:			WC	RK ORDER CHANG	iES					
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DATE	OTED	Description of NC		Corrective Action Sect Action Description	ion B		Verific	cation	Approval	Approval
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Work Order ID: 84908 Parent Item: D209-669-014 Parent Item Name: Skidtube RH			4908*)209-669-0	14*			art Date: 2	29/05/2012	Required Date: 16/07/2012 Required Qty: 1.00
AN5-36A Bolt	Purchased	No		110	Each	184.0000	4 **	4	
			Location 340 121181 121652 ST340 121708		134 34 100 50	Loc Code			- - - -
*AN960JD516 NAS1149D0563J *AN960.ID516* Washer	Purchased	No		110	Each	0.0000	8 **	8	M19542 20
MS21042L5 *MS21042L5* Nut	Purchased	No		110	Each	1,447.000	4 **	4	
			Location 300 121652 ST300 108827 116105 116548 117611 119109 17651	5	500 500 647 8 5 43 18 665 8	<u>Loc Code</u>		<u> </u>	- - - - - -
AN4-7A Bolt	Purchased	No		110	Each	124.0000	16 **	16 M	122/4/00/2/72
			<u>Location</u> ST356 117514 120770		24 24 00	Loc Code			- -

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Page 3

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Work Order ID: 84908

84908 *D209-669-014*

116289

119097

Parent Item Name:

Parent Item:

AN960JD416

Skidtube RH

AN960.JD416

D209-669-014

NAS1149D0463J Purchased

Location

Location

ST021

Location

ST021

ST351

110

Each

30

10

30.0000

Loc Code

32

Start Qty: 1.00

**

Start Date: 29/05/2012

32

Required Date: 16/07/2012

Required Qty: 1.00

D2929

Washer

Spacer

Manufactured

Manufactured

Manufactured

No

No

110

20 Each

Loc Qty

Loc Qty

86.0000

Loc Code

**

D2930

Spacer

D3405-041

No

No

53564

53563

110

86 Each

Loc Qty

102

102

Each

86

102.0000 **

Loc Code

6.0000

**

Location Loc Qty Loc Code ST478 6 62227 2 77000 2 82031 82032

110

W/O: DATE	STEP	PRO	·	ORK ORDER CHANG	ES By	Date	Qty	Approval Chief Eng /	Approval
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Oty	Approval	Approval
			PROCEDURE CHANGE					Prod Mgr	QC Inspector
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Part No:		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verifi	erification Approval		Approval
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Picklist Print May-29-12 1:05:06 PM										Page 5
Work Order ID: 84908 Parent Item: D209-669-014			4908* 209-669-0	11*						
Parent Item Name: Skidtube RH		1 /	1709-0 <u>09-</u> 0	14			tart Date: 2 Start Qty: 1		Required Date: Required Qty;	
AN4C47A	Purchased	No		110	Each	48.0000	4 **	4 M(o	730/2	S P
MS21043-4 *MS21043-4* Nut	Purchased	No	Location ST361 118451 119798 121009 121585	<u>L</u>	6 2 22 18 Each	Loc Code) 5 **	5) 	P
D3405-043 > *D3405-043*	Manufactured	No	Location FG 104603 ST301 119546 121162 121652	<u>L</u> .	40 40 1306 147 659 500 Each	Loc Code 2.0000	i **		- - - -	م ما ما م
Lug Assembly			<u>Location</u> ST478	<u>L</u> c	oc Oty 2	Loc Code	**	785	099 8	18/13/17/

82038

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DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	ion B Sign 8		cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84908

Parent Item:

D209-669-014

Parent Item Name: Skidtube RH

84908 *D209-669-014*

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-041

D3407-041

Manufactured

110

Each

Loc Qty

Loc Qty

78

28

50

27

6

27.0000

Loc Code

D3456-1

Manufactured No

Manufactured

82068 82108

82067

Location

ST463

Location

78842

83318

ST042

19 2 110 Each

156.0000

Loc Code

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Location Loc Qty FG 25701 7 ST044 149 80252 81876 48 83584 100 110 Each

78.0000

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Loc Code

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

- 1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:
 - a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
 - b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
 - c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

> UNCONTROLLED COPY SUBJECT TO AMENUMENT

A	NEW IS	SUE	AJS	09.02.24					
REV.			BY	BY DATE					
DESIGN		AJS	DART AEROSPA	DART AEROSPACE LTD					
DRAWN		AJS	HAWKESBURY, ONTARIO, CANADA						
CHECKED			DRAWING NO.		REV. A				
MFG. AF	PR.	N/An	DSI 9450	S	SHEET 1 OF 3				
APPRO\	/ED	N	TITLE		SCALE				
DE APPR.			SKIDTUBE INSTALLATIONS N						
DATE	00.01	2 2 4	COPYRIGHT © 2009 BY DART AEROSPACE LTD						

09.02.24



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5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	×						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		х					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			x				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				х			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			Х		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		х	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
		Ì					1	

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50	4	4	1	1	D3405-041	LUG ASSEMBLY
51	8	8	4	4	AN4C47A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21043-4	NUT
54			1	1	D3405-043	LUG ASSEMBLY
60	1	1	1	1	D3407-041	TOW RING ASSEMBLY
61	1	1	1	1	D3456-1	WASHER
62	1	1	1	1	MS21043-4	NUT
63	2	2	2	2	D3417-5	WASHER

WAS:

	Т	Τ		т т		
50	4	4	1	1	D2736-1	GHW LUG
51	8	8	4	4	AN4-46A	BOLT
52	16	16	8	8	D2570	BUSHING
53	8	8	4	4	MS21042L4	NUT (OR MS21042-4)
54			1	1	D2736-3	GHW LUG
60	1	1	1	1	D2968-041	TOW RING
61	1	1	1	1	AN970-4	WASHER
62	1	1	1	1	MS21042L4	NUT (OR MS21042-4)

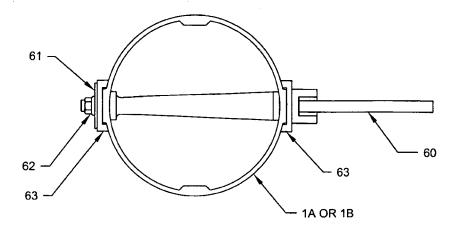
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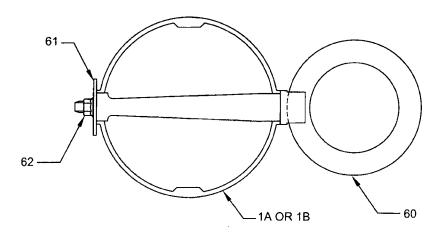
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INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD					
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO.	REV. A				
MFG. APPR.	N/A)	DSI 9450	SHEET3 OF 3				
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W/O:			W	ORK ORDER C	HANGES						
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